



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D2360

Job Sheet 169988



Part No: D2360

Job Qty: 5 ea

Part Name: Litter Tie Down Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/5/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining		18/02/18
100	Bandsaw	5 pcs	1/25/18	1/25/18	0.00	0.17	Bandsaw1		
110	CNC Vertical Machining	5 pcs	1/25/18	1/25/18	0.26	7.46	HAAS 1		
120	QC	5 pcs	1/25/18	1/25/18	0.00	0.00	QC2		
130	QC	5 pcs	1/25/18	1/25/18	0.00	0.00	QC8		18/02/18
140	HandFinish	5 pcs	1/25/18	1/25/18	0.00	0.39	HandFinish1		18-02-05
150	Powdercoat	5 pcs	1/25/18	1/25/18	0.00	0.30	Powdercoat1		18-02-05
160	QC	5 pcs	1/25/18	1/25/18	0.00	0.00	QC3		
170	Small Fab	5 pcs	1/26/18	1/26/18	0.00	1.57	Small Fab		
180	QC	5 pcs	1/26/18	1/26/18	0.00	0.00	QC5		
190	Packaging	5 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3		
200	QC21-SA	5 Ea	1/26/18	1/26/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: 12.65" Long

Descriptions: 110 - Machine as per Folio D2341 and Dwg D2341

150 - START TIME: 0:45 ONT: 300° FINISH: 4:15

170 - Assemble as per dwg D2360

Drill Holes #D. 24

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6201	5	0	0	0
170-Small Fab	-AN526C1032R18 F108079	5	49	0	0
	D2002-015 F164804	10	12	0	0
	D2345 B164981-286	5	8	0	0
	D2366 F166292 2x	10	14	0	0
	-D2367 F155485 2x	5	6	0	0
	D2372 F165514	10	61	0	0
	D2373 F158069	5	9	0	0
	D2444 S027862	5	10	0	0
	MS20470AD3-4 F1136851-1	5	7,083	0	0
	MS21042L3 S006901	15	3,336	0	0
	MS27039-1-13 F125654	5	424	0	0
	MS27039-1-15 M136554-302	10	409	0	0
	-NAS1149D0332J S020606	40	665	0	0
	-NAS1149D0363J S015269	10	4,434	0	0
	NAS679A3W F12409	5	151	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By _____		
			Lead hand / Supervisor _____		

Root Cause

Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐
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Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	OTHER : ☐
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Job No: 169988
Start up Operation 02/02/18

PART NO: D2360
Original Serial #: S038613
Revision:
Operation:
Change No:



Litter Tie Down Bracket



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DART AEROSPACE LTD		Work Order:	
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341 Rev: G		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	-		vern	mmml-05
2.75	+/-0.030	2.751	-			
Ø0.246	+0.005/-0.001	0.247	-			
Ø0.191	+0.005/-0.001	0.194	-			
R0.25	+/-0.030	0.25	-		RG	
R0.40	+/-0.030	0.400	-		"	
12.50	+/-0.030	12.500	-		tape	
11.750	+/-0.010	11.752	-		vern 12"	conv-02
11.00	+/-0.030	11.00	-		"	
7.00	+/-0.030	7.005	-		vern	mmml-05
6.250	+/-0.010	6.253	-			
5.50	+/-0.030	5.500	-			
1.50	+/-0.030	1.500	-			
0.750	+/-0.010	0.748	-			
0.400	+/-0.010	0.400	-			
1.584	+/-0.010	1.580	-			
2.610	+/-0.010	2.610	-			
0.250	+/-0.010	0.250	-			
0.844	+/-0.010	0.844	-			
Ø0.250	+/-0.010	0.250	-			
0.750	+/-0.010	0.752	-			
3.313	+/-0.010	3.312	-			
4.250	+/-0.010	4.250	-			
1.250	+/-0.010	1.250	-			

Measured by: mmml	Checked by: smk	QC Inspector:
Date: 18/02/02	Date: 18/02/05	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	
D	16.06.14	Dimensions updated per Dwg Rev G	KJ	